

Bentel # 1007

Work Order ID 55472

January 19, 2010 12:46:02 PM



Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 1/19/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-1-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B 10-1-K

(10)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

ant B.B 10/01/20

10

0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BF 10/01/20

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 55472

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Page 2

Item ID: D2435

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, 206

Start Date: 1/19/10 Start Qty: 8.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



QC

Quality Control



Packaging

Packaging



QC

Quality Control

K.A 10/01/21

10

0

10-1-21 sl (10x)

10/01/22

MF 10-1-21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 12:46:06 PM

Page 1

Work Order ID: 55472

Parent Item: D2435

Parent Item Name: Bearpaw, 206

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

431.9957

25.6000



B 10-1-19

UHMW 1" Black

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

400.248

112186

122.0164

113166

76.1264

113591

202.1052

Main Warehouse

ST

31.7477

111354

31.7477

10

113166

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DART AEROSPACE LTD		Work Order:	55472
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓			
B	5.500	+/-0.030	5.503	✓			
C	0.200	+/-0.030	.190	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.256	✓			
F	0.625	+/-0.030	.630	✓			
G	0.25 x 45°	+/-0.030	.250 x 45°	✓			
H	0.375	+/-0.010	.380	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.948	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.923	✓			
M	0.30	+0.030/-0.000	.315	✓			
N	0.375	+/-0.030	.380	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.012	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.75	✓			

Measured by:	LP	Audited by:	Q.A	Prototype Approval:	N/A
Date:	10/01/20	Date:	10/01/21	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	+

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DART

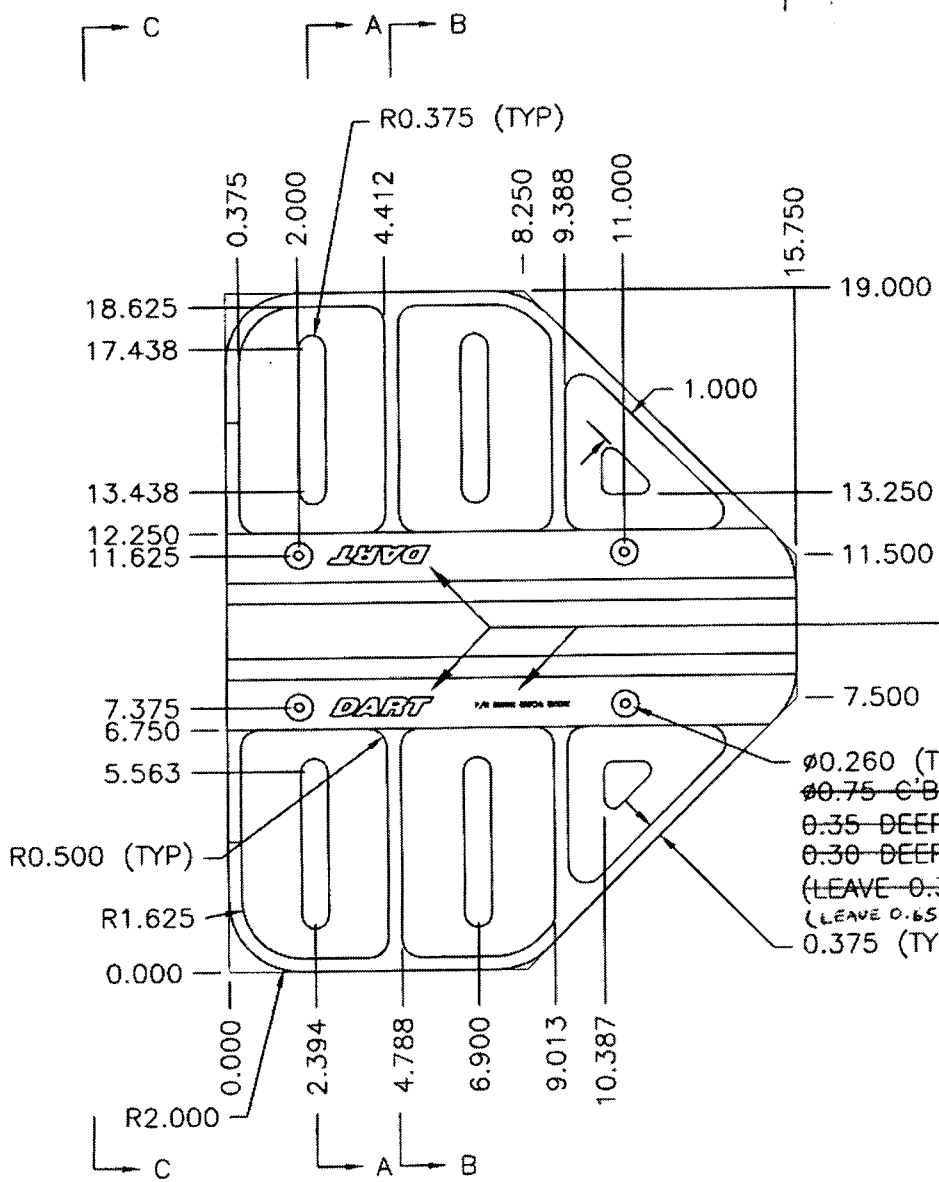


RELEASED
98.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	REV. E
98.05.19	BEARPAW	SHEET 1 OF 2
		SCALE
		1:5

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~KE~~

$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 ~~$\phi 0.75$ C'BORE~~ 0.30 DEEP FROM BOTTOM
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)
 0.375 (TYP)



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

EFFECTIVE DEOS
 9143

WORK ORDER
 NO. 55472
 12/10-1-19

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 1.00 THICK (MACHINE TO 0.950)

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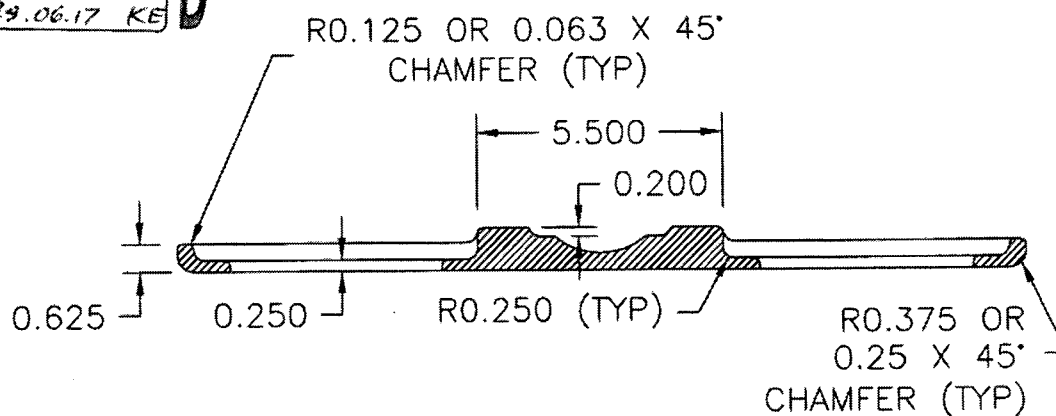
NOTE: Date & initial all entries



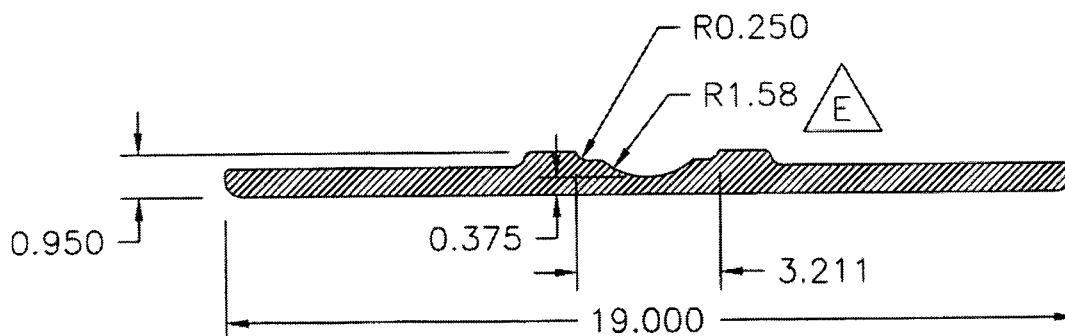
w/d 55 H72

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

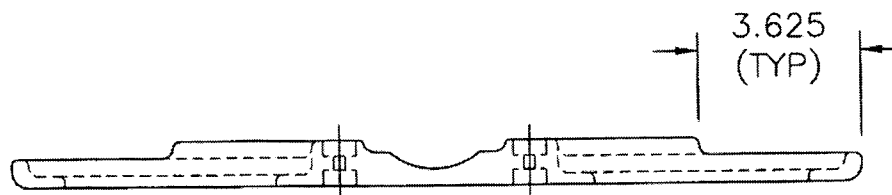
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99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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